

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.9/14.3,0.0/1.6File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000837**Date Inspected:** 12-Nov-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai,China**CWI Name:** Gu Xin Zhai**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** 89 Mock up**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector Tim McClendon arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China to periodically monitor welding and Quality Control (QC) functions. While on site the QA Inspector observed and/or discovered the following.

89 Meter Mock-Up Skin-A. Stiffener plates mp503 (PJP weld 1,2,13,and 14, CJP weld 9) mp504-1(PJP weld 3,4, 15 and 16, weld CJP weld 10) mp504-3 (CJP weld 7,8,19, and 20, PJP weld 12) to base plate MA21 were in the process of welding the root pass. Zhenhua Port Machinery Company (ZPMC) welders (A) Lei Lichno #053619 and (B) LI Shu Qaing #053609 certified for Flux Core Arc Welding (FCAW) in the 3G position were performing the welding of the root weld. QA inspector witnessed weld parameters being recorded by ZPMC QA inspectors. Welding parameters recorded by this QA Inspector were, (A) Amps 295 Volts 31.9, Travel Speed (T/S) 309 mm/min. & Temperature 128c and welder (B) Amps 307, Volts 31.5, T/S 297 mm/min. & Temperature 124c. The welding procedure used was WPS-B-T-2231-TC-U5-F. Welding was performed using Supercored 71H, . 4mm/diameter welding wire. The CWI present was Gu Xin Zhai. All related welding activity appeared to comply with codes and/or procedures.

WELDING INSPECTION REPORT

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Summary of Conversations:

Within body of report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	McClendon,Timothy	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer
